

Date: Friday, 12/21/2007 7:27:29 AM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	36513		
Estimate Number	10956		
P.O. Number	N/A	Part Number	D2565203
This Issue	12/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2565 REV E
First Issue	N/A	Project Number	N/A
Previous Run	36367	Drawing Revision	E
Written By		Material	N/A
Checked & Approved By	<u>PF071221</u>	Due Date	1/20/2008
Comment	Est: D 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC		
Qty: 10 Um: Each			
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W 	
Comment: Qty.: 1.8375 f(s)/Unit Total : 18.3750 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)		Batch No: M106015	 SR 08/01/10
2.0	BRAKE NC	NC BRAKE 	
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		SB 08/01/10	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr		SB 08/01/10 83	
4.0	QC5	INSPECT WORK TO CURRENT STEP 	
Comment: INSPECT WORK TO CURRENT STEP		S 08/01/11 4(10)	
5.0	POWDER COATING	POWDER COATING  M10637A  10X	
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3		M-1 08/01/12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/01/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36513

Part Number: D2565203

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Bk 08-0-12

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: ST271

CC 8/01/14 (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

H 08/01/14

Job Completion



U 08-01-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

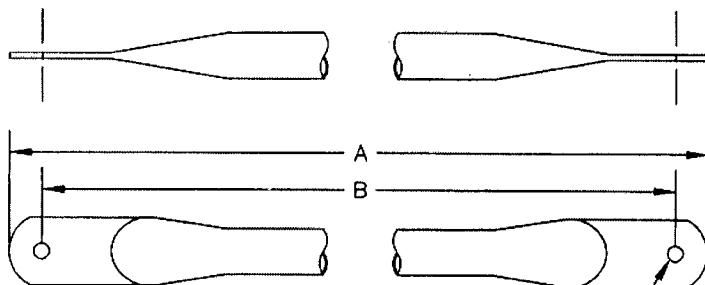
NOTE: Date & initial all entries



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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05



DIA 0.257 TO BE PUNCHED  
 "C" DIA TO BE OPENED MANUALLY  
 PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
 (REF. DART SPEC. M304TR0.750W0.049)  
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

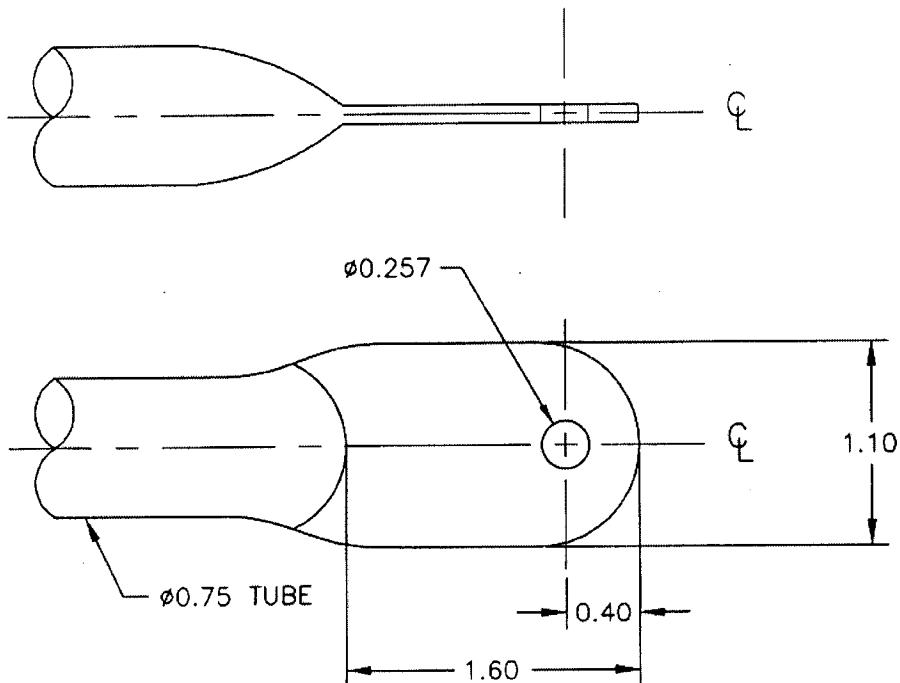
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 NO. 36513

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MJ</i>	APPROVED <i>JF</i>	DRAWING NO. D2638
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL
		SCALE 1:1
A	98.04.28	NEW ISSUE

**RELEASED**  
94/07/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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